

Date: Tuesday, 4/18/2006 10:06:42 AM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER	
Job Number	: 26686		Part Number	: D31701	
Estimate Number	: 11209		Drawing Number	: D3170 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 4/18/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/10/2006	
Previous Run	: 25771		Qty:	20 Um: Each	
Written By	: See J.A comment Below				
Checked & Approved By	: 06.04.18				
Comment	: Est Rev:A 02.10.11 New issue KJ				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S080	5052-H32 .080 Sheet 
		Comment: Qty.: 0.0655 sf(s)/Unit Total : 4.5864 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch: M100740
2.0	SHEAR	SHEAR  Comment: SHEAR Cut blanks: 11.990" x 0.750" (-0.00/+0.010) W 06.04.28
3.0	HAAS Water jet	HAAS CNC VERTICAL MACHINING #1  Comment: HAAS CNC VERTICAL MACHINING #1 Dwg Rev : Rev A2 Prog Rev : Rev A 1-Machine per folio FA282 and Dwg D3170 W 06.04.28 (20)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  Comment: INSPECT PARTS AS THEY COME OFF MACHINE R 06.04.28 (20)
5.0	QC8	SECOND CHECK  Comment: SECOND CHECK R 06.05.04 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/05/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:06:42 AM  
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Job Number: 26686

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

ML

06 08 28

(20)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD

06:05:04

20

8.0 QC3/5

INSPECT WORK/WING WALK



06:05:04 20

Comment: INSPECT WORK/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



06:05:04 20

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA.

10.0 DC

DOCUMENT CONTROL



06/05/04 20

Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06.05.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26686
Description: Spacer	Part Number:	D3170-1
Inspection Dwg: D3170 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<i>JM</i>	Audited by:	<i>J</i>	Prototype Approval:	N/A
Date:	<i>08/28</i>	Date:	<i>06.05.04</i>	Date:	N/A

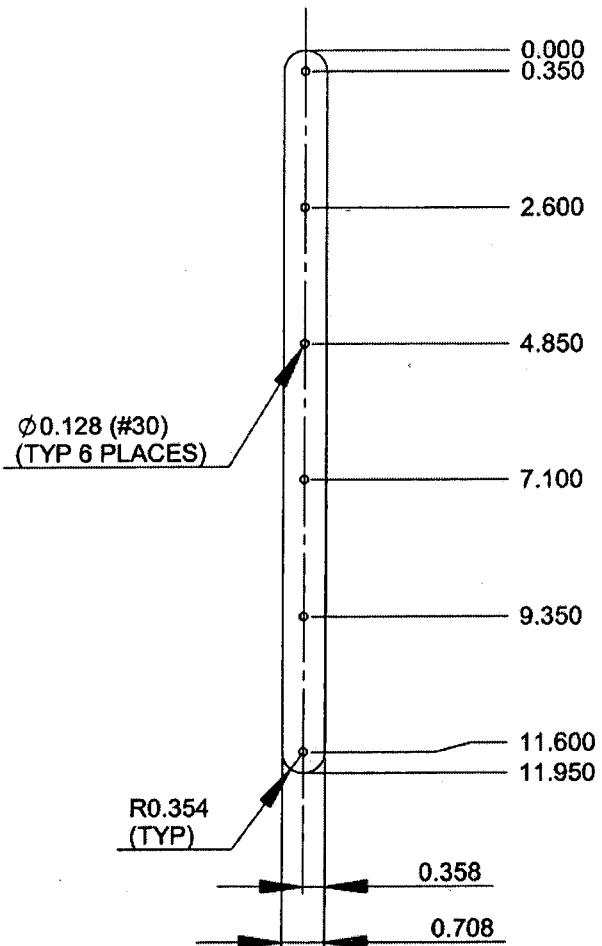
Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D3077-1	KJ/JLM	SJ



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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3170	REV. A SHEET 1 OF 1
DATE 02.09.11	TITLE SPACER	SCALE 1:3	
A	02.09.11	NEW ISSUE	

RELEASED  
02.09.20 *[Signature]*



### D3170-1 SPACER

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S-080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO

ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *26686*

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